

Date: Monday, 5/1/2006 3:57:41 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206L /407 STEP ASSY, LH		
Job Number	: 26879A					
Estimate Number	: 11702					
P.O. Number	: N/A			Part Number	: D2724041	
This Issue	: 5/1/2006 S.O. No. : N/A			Drawing Number	: D2724 REV C	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: C	
Previous Run	: 26346A			Material	: N/A	
Written By	: See Comment Below			Due Date	: 5/22/2006	
Checked & Approved By	: JG 06.05.02			Qty:	3 Um: Each	
Comment	: Est Rev:E As Per Ecn 766 06-01-06 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2622120C	Extrusion	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)		
	Qty Part # Description Batch:		
	1 D2622-120C Extrusion <u>324563</u>		<u>FF</u> 06.05.11
	Check Material for any Dents or Defects		
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
	Comment: LARGE FABRICATION RESOURCE 1		
	Cut D2724-1 using D2622 extrusion as per Dwg D2724		
	Deburr and bevel ends for welding		
3.0	D2734	206 Step Endplate	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)		
	206 Step Endplate		
	Pick:		
	Qty Part Number Description Batch		
	2 D2734 End Cap <u>324402</u>		<u>FF</u> 06.05.12
4.0	D34581	PLATE	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)		
	Pick:		
	Qty Part Number Description Batch		
	2 D3458-1 Plate <u>326778 = 2</u>		<u>FF</u> 06.05.13
			<u>326778 = 4</u>

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D34583 PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch  
2 D3458-3 Plate B26779 = 6

*J.E. 06-05-13*

3

6.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT followed by Jig  
DT (One End Only) M19173  
A/R AL ROD Batch: M15689

*J.E. 06-05-18*

3

Grind end cap welds flush

*J.E. 06-05-18*

3

7.0 QC5/9 WELD INSPECTION



Comment: WELD INSPECTION

*J.E. 06/05/18 (3)*

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*J.E. 06-05-18*

3

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*J.E. 06-05-18*

3

10.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

*J.E. 06-05-23*

3

Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig  
DT

*J.E. 06-05-23*

3

A/R AL ROD Batch: M19173

PTO

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-05-23	10.b	weldress grid end cap flush		ME	06-05-23	3		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/06/02  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-COMFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng					

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Job Number: 26879A

Part Number: D2724041

Job Number:



Seq. #: Machine Or Operation:

Description :

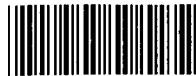
11.0

QC5/9

WELD INSPECTION



*J*



(3)

Comment: WELD INSPECTION

PD 06-05-23

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

DL 06/05/23 (3)

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-05-23 (3)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D2724 and QSI 005 4.4

a.m 06-05-29 (3)

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL 06/05/30 (3)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*N/A 06/05/01*

18.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*DL 06/06/02 (3)*

Job Completion



*W 06/06/02*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

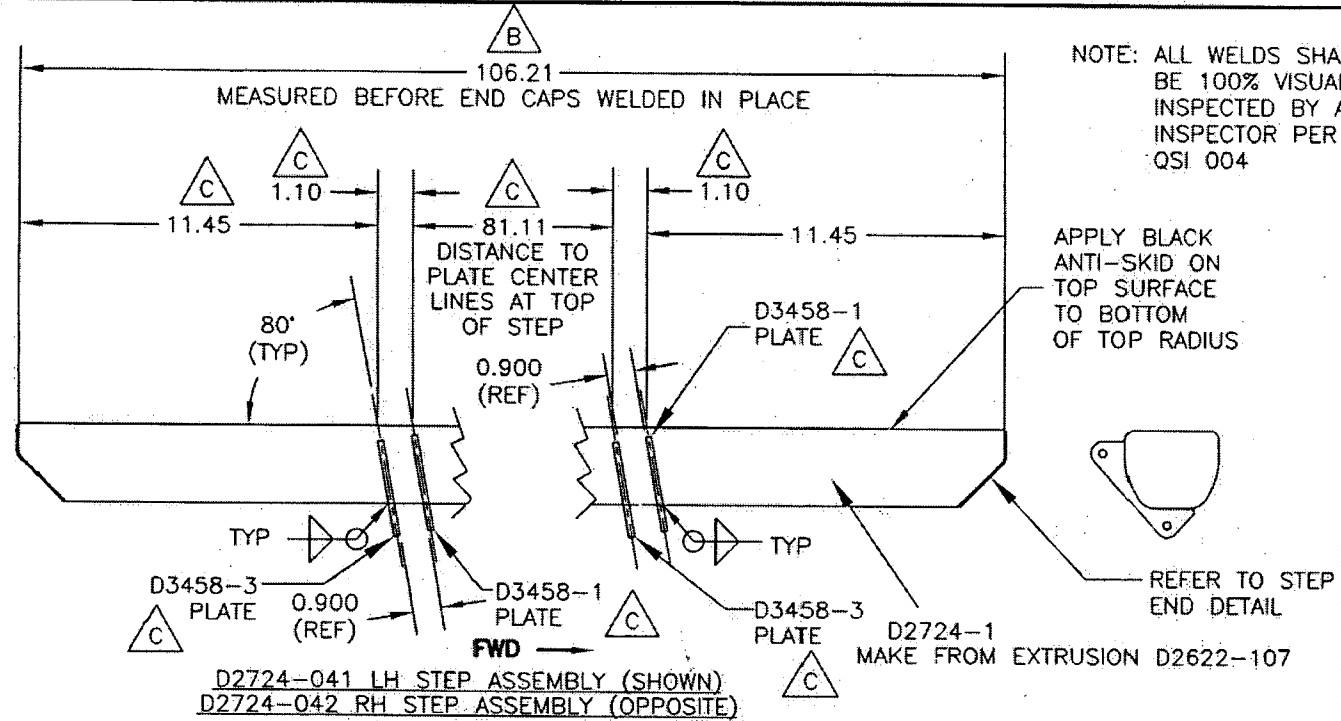
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng					

NOTE: Date & initial all entries

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WORK ORDER NO. 2689A  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
ENGINEERING COPY  
REF ID: 2005-041-042

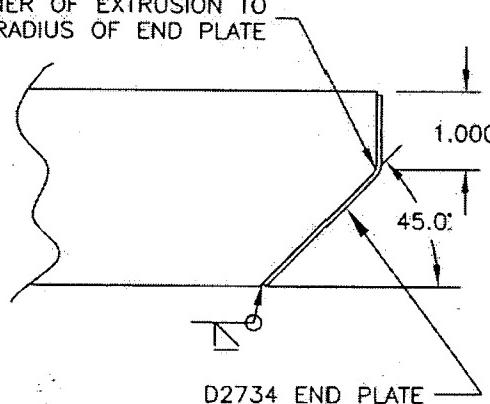


QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

#### D2724-041/-042 STEP ASSEMBLY

MAKE FROM EXTRUSION D2622  
WELD PER DART QSI 004

- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN KE	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HANDBLOCK, WA
CHECKED <input checked="" type="checkbox"/>	APPROVED <input checked="" type="checkbox"/>	DRAWING NO. D2724
DATE 05.09.19		REV. C
A	97.12.04	NEW ISSUE
B	98.10.19	UPDATED WELD DETAILS REVISED TOLERANCES
C	05.09.19	RE-DESIGN, ADD D3458-1/-3

SHEET 1 OF 1  
NTS  
SCALE

W/O:		WORK ORDER CHANGES							
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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